

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023871**Date Inspected:** 21-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Trial Assembly

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wong Xiang Pin and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3019Q

Weld No: 080,081

Welder: 049769

WPS-B-P-2114-FCM-1

Components; OBG 14E

PCMK: FB3240

Weld No: 019

Welder: 040769

WPS-B-P-2212-TC-U4b-FCM-1

WELDING INSPECTION REPORT

(Continued Page 2 of 7)

Components; OBG 13CE
PCMK: SEG3011M
Weld No: 122
Welder: 058102
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14E
PCMK: SEG3011N
Weld No: 281
Welder: 058102
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13CE
PCMK: KP3005-001
Weld No: 003,005
Welder: 037723
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CE
PCMK: KP3007-001
Weld No: 001,003
Welder: 037723
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG
PCMK: LD3034-001
Weld No: 148,149,124,125
Welder: 067570
WPS-B-P-2214-FCM-1

Components; OBG 13BW
PCMK: LD3034-001
Weld No: 148,149,124,125
Welder: 067829
WPS-B-P-2214-FCM-1

Components; OBG 13BW
PCMK: SEG3014S
Weld No: 055
Welder: 066398
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13AW

WELDING INSPECTION REPORT

(Continued Page 3 of 7)

PCMK: SEG3013AH
Weld No: 004
Welder: 066398
WPS-B-P-2213-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wong Xiang Pin and ABF QA Sha Zhi.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E
PCMK: SEG3019V
Weld No: 090,091
Welder: 217185
WPS-B-T-2232-ESAB

Components; OBG 14E
PCMK: SP3146
Weld No: 019
Welder: 217185
WPS-B-T-2232-ESAB

Components; OBG 13CE
PCMK: SEG3019V
Weld No: 119,121,123,125
Welder: 050242
WPS-B-T-2233-ESAB

Components; OBG 13CE
PCMK: SEG3019AG
Weld No: 038,051,040,042,044
Welder: 055491, 051356, 050977
Weld Repair No. B-WR21042
WPS-345-FCM-3G(3F)-ESAB-Repair

Components; OBG 13CE
PCMK: SEG3015B
Weld No: 171,175,179,183,187
Welder: 067876
WPS-B-T-2233-ESAB

Components; OBG 13CE
PCMK: SEG3015B

WELDING INSPECTION REPORT

(Continued Page 4 of 7)

Weld No: 172,173,176,177,180,181,184,185

Welder: 067876

WPS-B-T-2232-ESAB

Components; OBG 13CE

PCMK: SEG3015B

Weld No: 195,199,203

Welder: 037705

WPS-B-T-2233-ESAB

Components; OBG 13CE

PCMK: SEG3015B

Weld No: 196,197,200,201,204,205

Welder: 037705

WPS-B-T-2232-ESAB

Components; OBG

PCMK: BP2090-001

Weld No: 018,019,026,027,034,035

Welder: 070101

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Sun Tian Liang and An Qing Ziang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG

PCMK: SEG3014S

Weld No: 036

Welder: 040270

Weld Repair No. B-WR21064

WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG

PCMK: SEG3013M

Weld No: 098

Welder: 047864

Weld Repair No. B-WR20695

WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 13AW

PCMK: LD3034-001

WELDING INSPECTION REPORT

(Continued Page 5 of 7)

Weld No: 148,149,124,125
Welder: 067829
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13AW
PCMK: SEG3013AH
Weld No: 070
Welder: 066674
WPS-B-P-2211-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Sun Tian Liang and An Qing Ziang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BW
PCMK: SA3122
Weld No: 002,008,011
Welder: 045143
WPS-B-T-2231-ESAB

Components; OBG 13CW
PCMK: SA7514
Weld No: 003,008,011
Welder: 045240
WPS-B-T-2231-ESAB

Components; OBG 13AW
PCMK: SEG3013J
Weld No: 164,178
Welder: 062708
WPS-B-T-2133-ESAB

Components; OBG 13AW
PCMK: SEG3013J
Weld No: 170,184
Welder: 048433
WPS-B-T-2133-ESAB

Components; OBG 14W
PCMK: SEG3020AL
Weld No: 030,032,034,036,038,040,042,044,046,048
Welder: 066881, 067275

WELDING INSPECTION REPORT

(Continued Page 6 of 7)

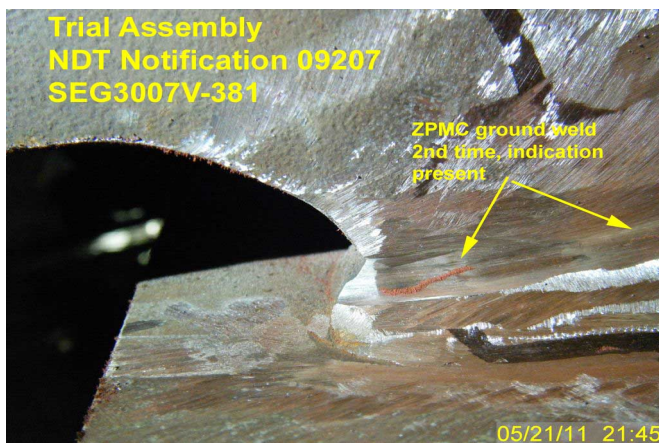
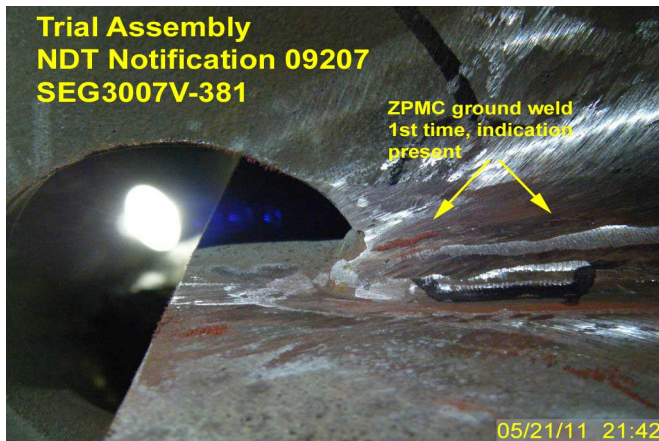
WPS-B-T-2233-ESAB

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG CB18. The weld designations reviewed are as follows:

SEG3007V-067,068,070~087,385~404,089~102,365~384,117~128,345~364,278,279,105,106

This Quality Assurance (QA) Inspector, responding to NDT notification 09207, performed 100% Visual Inspection (VT) and approximately 15% Magnetic Particle Testing (MT) of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. The component OBG CB18 at SEG3007V weld number 381 was found to have an indication 35mm long. This QA informed ZPMC QC Inspectors Xie Gen Lin and AB Flour QA Inspector CK Chen of the problem. A TL-015 Incident Report, and a TL6028 MT report, will be documented for the accordance. (see photos)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

“No relevant conversations.”

WELDING INSPECTION REPORT

(Continued Page 7 of 7)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly
----------------------	---------------

Quality Assurance Inspector

Reviewed By:	Riley,Ken
---------------------	-----------

QA Reviewer
